

Date: Wednesday, 10/3/2007 8:39:00 AM  
 User: Kim Johnston

## Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
 Job Number : 34985  
 Estimate Number : 13042  
 P.O. Number : N/A Part Number : D2127251027  
 This Issue : 10/3/2007 S.O. No. : N/A Drawing Number : D2127251 REVB  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : N/A Material : N/A  
 Due Date : 10/9/2007 Qty: 5 Um: Each  
 Written By :  
 Checked & Approved By : 07.10.03  
 Comment : Est. A New Issue 07-10-02 DD verified by: EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T1500W125 6061T6 TUBE 1.500X .125W



Comment: Qty.: 0.3308 f(s)/Unit Total : 3.3075 f(s)

6061T6 TUBE 1.500X .125W

Batch: M18639

DSR 07/10/05

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1-Turn as per Dwg D212-725-1

2-Deburr

DSR 07/10/05 (5)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSR 07/10/05 (5)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

DSR 07/10/05 (5)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-10-11

(5)

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F110/11 (5X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/3/2007 8:39:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 34985

Part Number: D2127251027

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/10/11 SQ SX

8.0

QC21

FINAL INSPECTION/W/O RELEASE



5

Comment: FINAL INSPECTION/W/O RELEASE

Don't allow

Job Completion



U 8/10/12

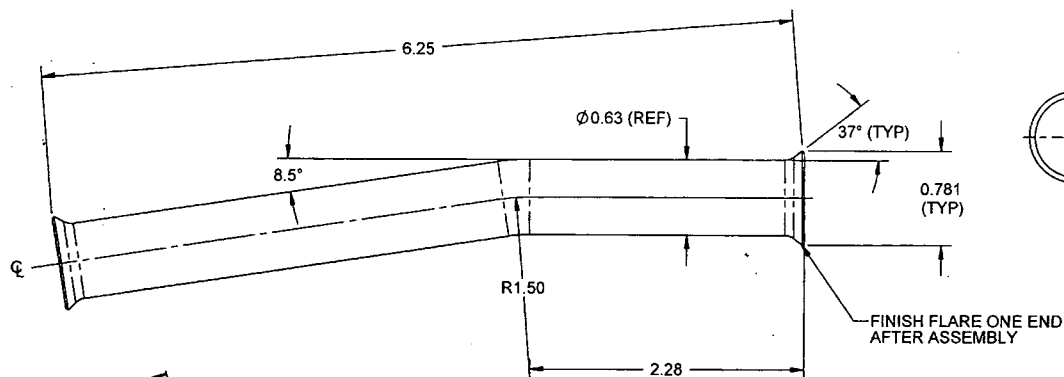
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

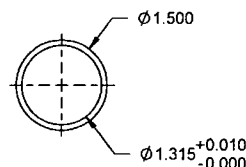
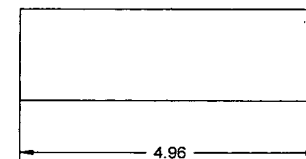
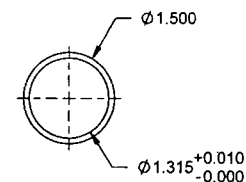
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

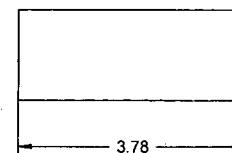


**D212-725-1-013 TUBING**  
MANUFACTURE PER TEMPLATE DT8906

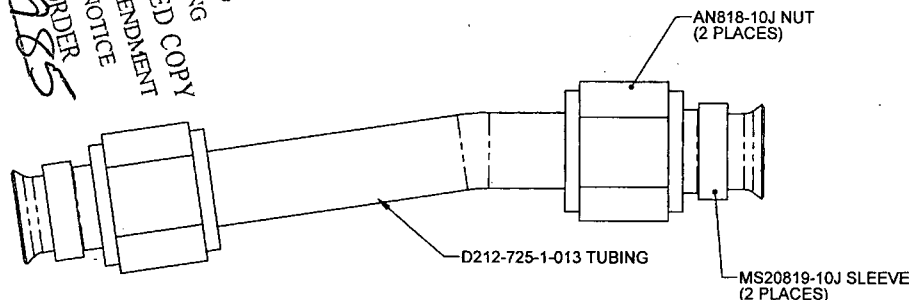
**D212-725-1-025 SPACER**  
SCALE 1:2



**D212-725-1-027 SPACER**  
SCALE 1:2



NO 34985  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



**D212-725-1-903 TUBE ASSEMBLY**

**D212-725-1-025/-027 NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D212-725-1-013 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.035 WALL (REF. DART SPEC. M304TR0.625W0.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED 	DRAWING NO. <b>D212-725-1</b> REV. B SHEET 6 OF 44
DATE <b>07.05.11</b>	TITLE <b>212S DETAIL PARTS</b>	SCALE 1:1
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